



Dart Hawkesbury
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D4634-145
Job Sheet 167078-G



Part No: D4634-145

Job Qty: 1 ea

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	D.M.L 17-12-20
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	D.M.L 17-12-20
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	D.M.L 17-12-20
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	17-12-20
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	D.M.L 2017-12-20
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138699 Expiry Date 18/01/19 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-5 <u>5022342</u>	1 <u>502232</u>	3	0	0
	D4636-5 <u>5022344</u>	1	43	0	0
	D4647-1 <u>5022341</u>	1	4	0	0
	D4664-5 <u>5022340</u>	6	39	0	0
	D4712-1 <u>5022339</u>	1	4	0	0
	D4732-17 <u>5022338</u>	1	0	0	0
	D4732-23 <u>5022336</u>	1	1	0	0
	D4732-27 <u>5022335</u>	1	1	0	0
	D5021-5 <u>5022334</u>	1	1	0	0
	MPNY-750S-9-C <u>5022333</u>	39	570	0	0
	MS20426AD3-4 <u>5022332</u>	4	5,055	0	0
	MS20426AD4-6 <u>5022331</u>	2	2,797	0	0
	MS21059L08 <u>5022330</u>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval ☐
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Description Work Order Deviation	Disposition
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DART
AEROSPACE
S022952

Aft, Center Ceiling Replacement Panel Assembly

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CANADA
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www.dartaerospace.com

Completed By

Lead hand / Supervisor
Approval VerificationQC / QA Coordinator
Approval

Root Cause	
Environment ☐	No Re-verification ☐
Design ☐	Operator ☐
Doc/Data ☐	Offset/Setup ☐
Equip/Tooling ☐	Supplier ☐
Handling/Pre ☐	Training ☐
Material ☐	Use for Testing ☐
Internal Transport ☐	Poor Information ☐
Tribal Knowledge ☐	Rushing ☐
LOA ☐	Product Improvement ☐
Substation ☐	Process Improvement ☐
Past Expiry Date ☐	Manufacturing Process ☐
Misidentified ☐	Past Due ☐

PART NO: D4634 - 145
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/15/17
Job No: 167078 - G

☐	Positioned Wrong
☐	Outside Dimensions
☐	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Drawing
☐	Finish
☐	Misread
☐	Turning Sequence

Heat Treat

Wave/Twist in Tube

Marks/Chatter

Instructions Incomplete/Unclear

Drill Holes

Fit/Function

Misaligned/off center

OTHER :